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वस्त्रादि — सूती नीला विमान डाक थैला —  
विशिष्टि  
( पहला पुनरीक्षण )

Textiles — Cotton Blue Airmail Bags —  
Specification  
( First Revision )

ICS 59.080.30

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## FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Made-up Textiles (Including Ready-Made Garments) Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1984. The present revision has been made in the light of experience gained since its last revision and to incorporate the following major changes:

- a) Requirement for Cotton Dosuti (240 g/m<sup>2</sup>) used for making bag has been revised.
- b) Amendment 1 has been incorporated in the standard
- c) Marking, packaging and sampling clauses have been modified
- d) References to Indian Standards have been updated

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard*

## TEXTILES — COTTON BLUE AIRMAIL BAGS — SPECIFICATION

*(First Revision)***1 SCOPE**

**1.1** This standard prescribes constructional details and other requirements of Airmail Postal Bags, made from Cotton Dosuti.

**2** The standards listed in Annex A contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards.

**3 MANUFACTURE**

**3.1** The bags shall be manufactured from Cotton Dosuti (240 g/m<sup>2</sup>) conforming to SI No. IV of IS 179 in all respects except for colour fastness which shall be according to 4 of this standard. The colour of the cloth shall be blue.

**3.2** The bags shall be made from single piece of cloth, except AM I and AM II types.

**3.2.1** Bag of AM I and AM II types shall be made out of 2 pieces one for the sides and the other forming the bottom. The bottom portion should be of a square shape measuring 35 × 35 cm, the around measurement being 140 cm (*see* Fig. 1).

**3.3 Seam** — The sides of the bag shall be machine stitched using two rows of stitches. The first turning-in of the cloth should be about 5 mm and the second turning-in of the cloth should be about 10 mm. The stitches shall be of even tension throughout with all the loose ends securely fastened. The number of stitches per decimetre shall be 28, *Min.* The seam should be on the inner side of the bag to prevent fraying.

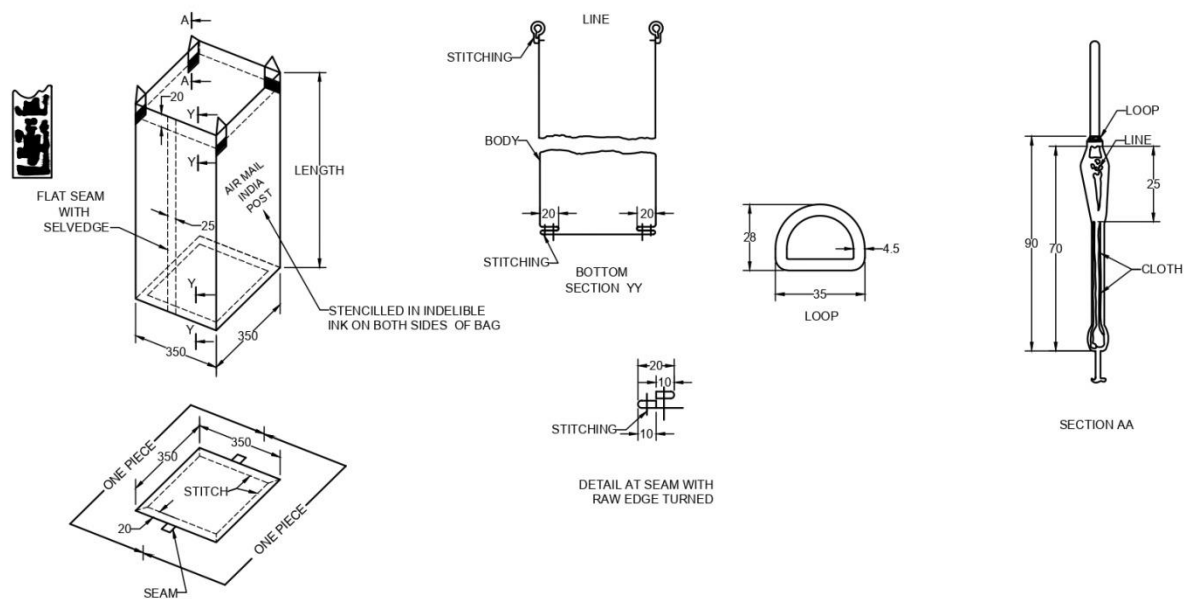
**3.4 Tabs** — Tabs for fixing cast aluminium loops to the bags shall be of the same basic material as of the bags. The tabs shall be secured with double layer of cloth and neatly stitched on the bags at the mouth. They shall be of a dimension commensurate with the size of the bags (*see* Fig. 1 or Fig. 2).

**3.5 Thread** — The sewing thread used for stitching (*see* 3.3 and 3.4) shall conform to 36s/6 (165 dtex × 6) of IS 1720. The colour and dye fastness of the sewing thread should be same as that of the basic material.

**3.6 Loops** — The cast aluminium loops shall not be finer than 4.5 mm in diameter. The approximate dimensions of the loops are shown in Fig. 1 or Fig. 2. Two or four loops, depending upon the size of the bag, shall be provided on each bag (*see also* Table 1).

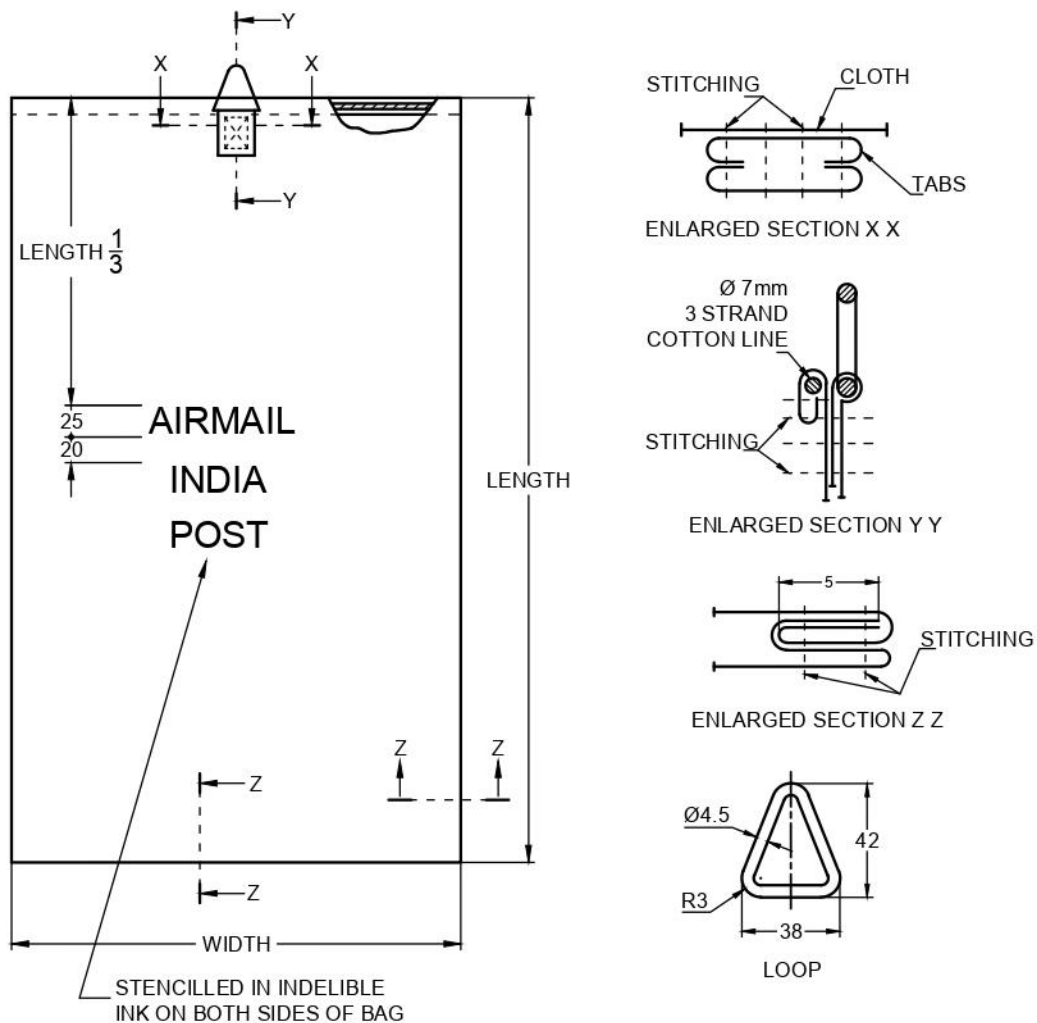
**Table 1 Particulars of Cotton Blue Airmail Bags***(Clauses, 3.2 and 4.2)*

Sl No.	Type of Bag	Size of Bag cm	Size (Height x Thickness of Letters) for Marking on Bag cm	Colour of Marking	No. of Loops per Bag
(1)	(2)	(3)	(4)	(5)	(6)
i)	Air mail, AM I	105 x 35 x 35	5 x 1	Yellow	4
ii)	Air mail, AM II	75 x 35 x 35	5 x 1	Yellow	4
iii)	Air mail, AM III	50 x 35	2.5 x 0.6	Yellow	2



All dimensions in millimetres.

**FIG. 1 AIRMAIL BAG OF AM I AND AM II TYPES**



All dimensions in millimetres.

FIG. 2 AIRMAIL BAG OF AM III TYPE

**3.7 Mouth Reinforcing** — The mouth of the bag shall be reinforced by providing a cotton line of 7 mm diameter securely stitched to it. The line shall be spliced to a length of 5 cm and whipped properly before being stitched with the body of the bag.

**3.8 Freedom from Defects** — The bags should be free from sewing and other fabrication and basic fabric defects.

#### 4 REQUIREMENTS

**4.1** The general make up of the bag shall be as shown in Fig. 1 for AM I and AM II and Fig. 2 for AM III.

**4.2** The size, type and other related details of the bags shall generally be as given in Table 1. A tolerance of  $\pm 1$  cm is allowed on size of bag.

**4.3** If in order to illustrate or specify the indeterminable characteristics, such as workmanship, general appearance, lustre, feel and shade of the bag, a sample has been agreed upon and sealed, the supply

shall be in conformity with the sample in such respects.

**4.3.1** The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

**4.4 Colour Fastness** — The basic cloth shall be fast to light, washing and rubbing. The fastness rating shall be as given below when tested by the methods given against each:

<i>Colour fastness to</i>	<i>Rating Method</i>	<i>Method</i>
a) Light	4 or better	IS/ISO 105-B02 or IS/ISO 105-B01
b) Washing		
i) Change in colour	4 or better	IS/ISO 105-C10
ii) Staining on adjacent fabric	4 or better	
c) Rubbing (Dry and wet)	4 or better	IS/ISO 105-X12

## 5 PACKING AND MARKING

**5.1** The bags shall be packed as agreed to between the buyer and the seller.

**5.2 Marking on the Bag** — The marking on the bags shall be as required by the Postal Department (*see* Table 1). It shall be done neatly using indelible ink (*see* IS 394) on both sides of the bag. A typical positioning and size of the letters is shown in Fig. 1. Each bag shall also be marked, on the inner side, using indelible ink (*see* IS 394), with the Manufacturer's Name or Trade-Mark, Size, together with the Year of Manufacture.

## 5.3 BIS Certification Marking

The bags may also be marked with the Standard Mark.

**5.3.1** The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment

schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.

## 6 SAMPLING

**6.1 Lot** — The quantity of postal bags of same designation delivered to a buyer against a dispatch note shall constitute a lot.  
**6.2** The conformity of the lot shall be determined on the basis of the tests carried out on the sample selected from it.

**6.3** Unless otherwise agreed to between the buyer and the seller, the number of bags to be selected at random from a lot shall be according to col 1 and 2 of Table 2.

**Table 2 Sample Size and permissible number of Non-conforming bags**

(Clause 6.3)

Sl. No.	Lot Size	Sample Size	Permissible of Non-Conforming Bags
(1)	(2)	(3)	(4)
i)	Up to 100	13	1
ii)	101 to 150	20	2
iii)	151 to 300	32	3
iv)	301 to 500	50	5
v)	501 to 1 000	80	7
vi)	1 001 to 3 000	125	10
vii)	3 001 and above	200	14

**6.4** The number of bags selected according to **6.3** shall be examined for seam, tabs, aluminium loops, reinforcement of the

mouth, marking, freedom from defects and the dimensions.

**6.4.1** The number of bags to be examined for colour fastness shall be 5 for lot size less than 1 000 and 10 otherwise.

**6.5 Criteria for Conformity** — The lot shall be declared as conforming to the requirements of this specification if the following conditions are satisfied:

- a) The number of bags found not in conformity with the requirements

for any one or more of the characteristics mentioned in **6.4** is less than or equal to the corresponding number given in col 3 of Table 2.

- b) All the test specimens tested for colour fastness are found satisfactory.

**ANNEX A**

*(Clause 2)*

**LIST OF REFERRED INDIAN STANDARDS**

<i>IS No.</i>	<i>Title</i>
179: 2009	Cotton dosuti — Specification ( <i>third revision</i> )
394: 1985	Specification for ink, cloth marking ( <i>second revision</i> )
1720: 1978	Specification for cotton sewing threads ( <i>first revision</i> )
IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness — Part B01 Colour Fastness to Light — Daylight
IS/ISO 105-B02 : 2014	Textiles — Tests for colour fastness — Part B02 Colour fastness to artificial light — Xenon arc fading lamp test
IS/ISO 105-C10 : 2006	Textiles — Tests for colour fastness — Part C10 Colour fastness to washing with soap or soap and soda
IS/ISO 105-X12 : 2016	Textiles — Tests for colour fastness — Part X12 Colour fastness to rubbing ( <i>first revision</i> )



**ANNEX B***(Foreword)***COMMITTEE COMPOSITION**

Made-up Textiles (Including Ready-Made Garments), TXD 20

<i>Organization(s)</i>	<i>Representative(s)</i>
Northern India Textile Research Association, Ghaziabad	DR ARINDAM BASU ( <b><i>Chairman</i></b> )
Ahmedabad Textile Industry's Research Association, Ahmedabad	SHRIMATI DEEPALI PLAWAT SHRI JIGAR DAVE ( <i>Alternate</i> )
Apparel Export Promotion Council, Gurgaon	SHRIMATI CHANDRIMA CHATTERJEE SHRI K. J. MARIJAN ( <i>Alternate</i> )
Birla VXL Limited, Faridabad	SHRI AJIT KUMAR SHRI P. K. DAS ( <i>Alternate</i> )
Clothing Manufacturers' Association of India, Mumbai	REPRESENTATIVE
Department of Posts, Ministry of Communications and IT	DR AMARPREET DUGGAL SHRI SIDDHARTHA BUCHCHAN ( <i>Alternate</i> )
Directorate General of Quality Assurance, New Delhi	SHRI A. CHAUDHURY SHRI P. DE ( <i>Alternate</i> )
Directorate of Standardization, Ministry of Defence	REPRESENTATIVE
Garment Exporters Association, New Delhi	SHRI H. K. L. MAGU
Indian Institute of Technology, New Delhi	DR DEEPTI GUPTA
Intertek Testing Services (I) Pvt Ltd, New Delhi	SHRI DILIP GIANCHANDANI SHRI HARIT SARDANA ( <i>Alternate</i> )
Ministry Of Defence (R&D), Kanpur	SHRI HIRDAY RAM SHRI K. K. GUPTA ( <i>Alternate</i> )
National Institute of Fashion Technology, New Delhi	PROF VANDANA NARANG PROF MONIKA GUPTA ( <i>Alternate</i> )

<i>Organization(s)</i>	<i>Representative(s)</i>
National Textile Corporation Limited, New Delhi	SHRI H. .S SACHDEV
Northern India Textile Research Association, Ghaziabad	SHRI VIVEK AGARWAL
Office of the Textile Commissioner, Mumbai	SHRI SAURABH KULKARNI SHRI G. PITCHAIMANI ( <i>Alternate</i> )
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Reliance Industries Limited, Mumbai	SHRI M. S. VERMA SHRI AJAY GUPTA ( <i>Alternate</i> )
Sarla Fabric Pvt Ltd, Mumbai	SHRI SOMES BHAUMIC SHRI RAJNEESH RAI ( <i>Alternate</i> )
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Textiles Committee, Mumbai	SHRI J. D. BARMAN SHRI GANESH P BANGAR ( <i>Alternate</i> )
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Shriram Institute for Industrial Research, Delhi	SHRI VINAY KUMAR SAMANIA DR BHUVNESHWAR RAI ( <i>Alternate</i> )
BIS Directorate General	SHRI J. K. GUPTA, SCIENTIST 'E' AND HEAD (TXD) [REPRESENTING DIRECTOR GENERAL ( <i>Ex-officio</i> )]

*Member Secretary*

SHRI P. N. MURALI  
Scientist 'D' (TXD), BIS



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This Indian Standard has been developed from Doc No.: TXD 20 (18200).

### Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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